

Monday, August 24, 2015 9:25:53 AM

1.35.902

Page 1

N900040100

Setup Start *NS1*

Stop ***NS2***

10

Cust Item ID:

10

Customer:

Reference:

Approvals: Process Plan: MLS Date: AUG 24 2015 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run	Start	*NR1*
	Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr	
D4016	A	

100	Cut blanks as per folio	0.00
-----	-------------------------	------

100

Bandsaw	Memo	0.00
---------	------	------

Jeaspa Bandsaw CUT BLANK 1.00" LONG

110	0.00
-----	------

1 10

HAAS 1	Memo	0.00
--------	------	------

HAAS CNC vertical machine #1 MACHINE AS PER FOLIO FA869 AND DWG

FOLIO REV: AA

DWG REV: A

DEBURR

Work Order ID 135902

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135902

Page 2

Item ID: D4016-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Hinge Half, Base
Start Date: 8/24/2015 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 8/24/2015 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120						16	0		SL15-9-1
QC	Memo	0.00							
Quality Control									
130	QC8- Inspect parts - second check	0.00							
130						10	0		DAS 14 9-89
QC	Memo	0.00							15/09/02
Quality Control									
160	Identify as per dwg & Stock Location: _____	0.00							
160						10x			DAS 43 9-89
Packaging	Memo	0.00							SEP 02 2015
Packaging	LOCATION: WA004								

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Page 3

Item ID: D4016-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Hinge Half, Base
Start Date: 8/24/2015 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 8/24/2015 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

MLJ SEP 02 2015

542 0150902

Picklist Print

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Page 1

Work Order ID: 135902

135902

Parent Item: D4016-1

D4016-1

Parent Item Name: Hinge Half, Base

Start Date: 8/24/2015

Required Date: 8/24/2015

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A NEW ISSUE 09-11-27 JLM VERIFIED BY :DD IPP Rev:B
as per dwg REV.A DD 10.02.22 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B1.000X1.000		Purchased			No	100	f	12.2465	0.08	0.8			

M304B1 000X1 000

**

SL 15-8-26

304 bar 1.00 x 1.00

Location

Loc Qty

Loc Code

MAT009

12.2465

M130451

1.1725

M132546

11.074

*.89

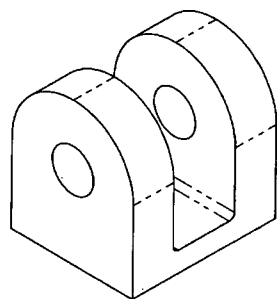
DART AEROSPACE LTD		Work Order:	135902
Description: Hinge Half, Base		Part Number:	D4016-1
Inspection Dwg: D4016 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

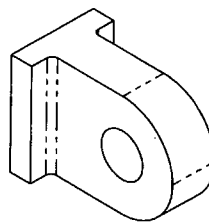
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.875	+/-0.010	0.874	/		VERU	SL-10
0.25	+/-0.030	0.242	/			
0.38	+0.030/-0.000	0.385	/			
R0.03	+/-0.030	0.030	/			
0.13	+/-0.030	0.125	/			
0.88	+/-0.030	0.875	/			
Ø0.257	+0.006/-0.001	0.257	/			
R0.38	+/-0.030	0.38	/			
0.500	+/-0.030	0.500	/			
0.75	+/-0.030	0.751	/			

Measured by:	J	Audited by:	DAS 14 9-89	Preliminary Approval:	
Date:	15-9-1	Date:	15/09/02	Date:	

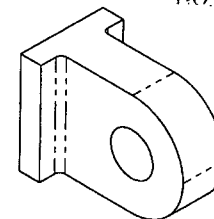
Rev	Date	Change	Revised by	Approved
A	10.06.07	New Issue	KJ	



D4016-1 HINGE HALF, BASE



D4016-3 HINGE HALF, LID



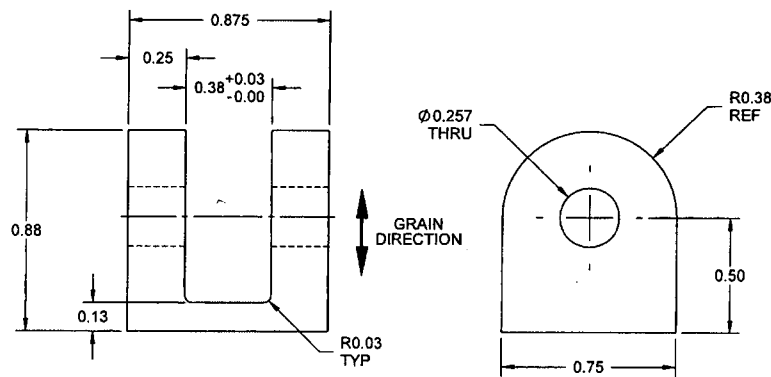
D4016-5 HINGE HALF, LIGHT LID

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

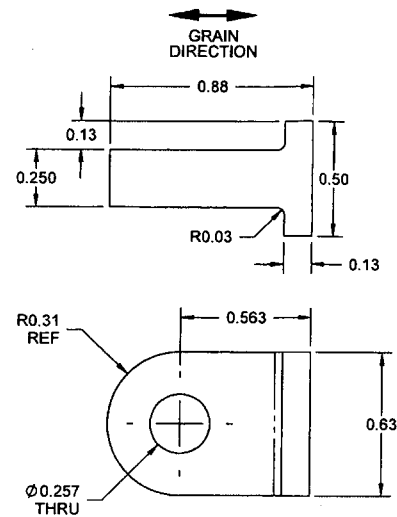
NO. 135902 MLJ
13-08-24

RELEASED
2010-02-16
MD

A		NEW ISSUE		JPH	10.01.29
REV.		DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			REV. A
DRAWN	AJS				
CHECKED		DRAWING NO.	D4016	SHEET 1 OF 2	
MFG. APPR.		TITLE			SCALE
DE APPR.		BASKET HINGE			NTS
DATE	10.01.29	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE, UNCLASSIFIED AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			



D4016-1 HINGE HALF, BASE



D4016-3 HINGE HALF, LID

D4016-5 HINGE HALF, LIGHT LID

NOTES:

1) MATERIAL -1 & -3: 304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M304B

-5: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR,
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT -1: 0.09 lbs

-3: 0.04 lbs

-5: 0.01 lbs

RELEASED
2010-02-16

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4016	REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 2 OF 2	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BASKET HINGE	NTS
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